

Stop today to Eng

Work Order ID 64480

December 6, 2010 2:36:06 PM



PRELIMINARY ISSUE

Page 1

Item ID: D4274-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Fwd Support

Start Date: 12/06/10 Start Qty: 2.00



Cust Item ID:

Required Date: 12/06/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4274

PBT C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

AB 10-12-6

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

AB 10-12-6

Work Order ID 64480

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Item ID:	D4274-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Plate, Fwd Support					
Start Date:	12/06/10	Start Qty:	2.00		Cust Item ID:	
Required Date:	12/06/10	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	- inspect to Rev C Dry only. 8/10/10/06 (x2)						
130 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00	RD1320						
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL

POSITIVE 10-12-06

AUTH

DATE

mf
10-12-06

DART AEROSPACE LTD		Work Order: 64480
Description: PLATE FWD. Support		Part Number: D4274-1
Inspection Dwg: D4274-1, Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.133	X		✓ RB02	
Ø .191	+ .005 - .001	.193	X		✓	
Ø .250	+ .005 - .001	.252	X		✓	
Ø .257 .257	+ .006 - .001	.260	X		✓	
4.40	± .030	4.412	X		✓	
3.65 3.75	± .030	3.750 3.65	X		✓	
4.85	± .030	4.858	X		✓	
.80	± .030	.808	X		✓	
5.70	± .030	5.702	X		✓	
2.10	± .030	2.10	X		✓	
1.30	± .030	1.293	X		✓	
1.00	± .030	1.003	X		✓	
1.40	± .030	1.409	X		✓	
.335	± .010	.336	X		✓	
.750	± .010	.753	X		✓	
.380	± .010	.383	X		✓	
2.80	± .030	2.802	X		✓	
1.75	± .030	1.749	X		✓	
1.05	± .030	1.056	X		✓	
.303	± .010	.303	X		✓	
.375	± .010	.374	X		✓	
.190	± .030	.190	X		✓	
.75	± .030	.748	X		✓	

Measured by: RB	Audited by: S	Prototype Approval:
Date: 10-26	Date: 10/12/06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 64480
Description: PLATE, FWD. SUPPORT		Part Number: D4074-1
Inspection Dwg: D4074-1, Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

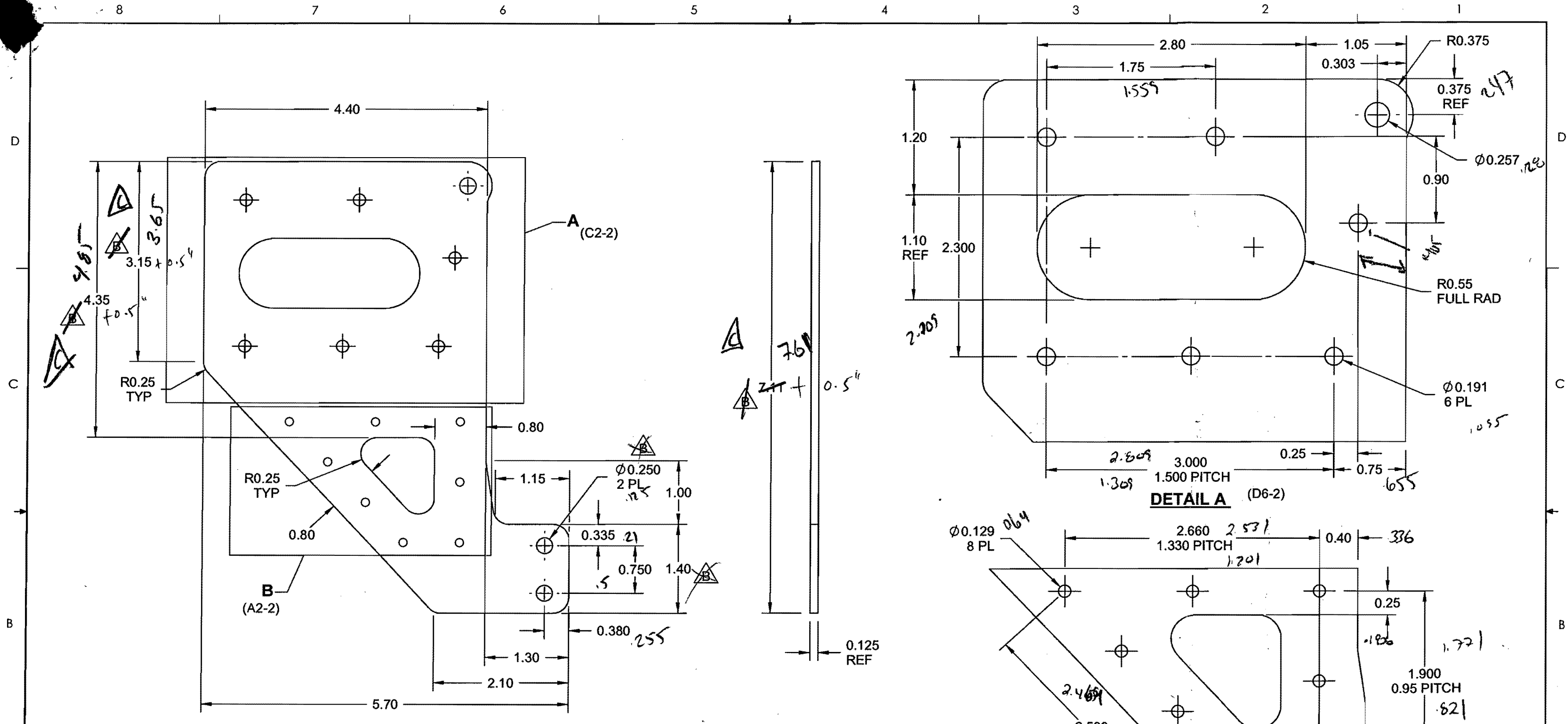
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	±.010	3.003	✓		✓ 1B02	
1.500	±.010	1.502	✓		✓	
2.300	±.010	2.296	✓		✓	
1.10	±.030	1.097	✓		✓	
1.20	±.030	1.209	✓		✓	
2.660	±.010	2.661	✓		✓	
1.330	±.010	1.332	✓		✓	
.40	±.030	.403	✓		✓	
.25	±.030	.252	✓		✓	
1.900	±.010	1.900	✓		✓	
.95	±.030	.948	✓		✓	
.884	±.010	.891	✓		✓	
2.598	±.010	2.599	✓		✓	
.866	±.010	.863	✓		✓	
7.61	±.030	7.614	✓		✓	
.125	±.010	.117	✓		✓	

Measured by: AB	Audited by: S	Prototype Approval:
Date: 10-12-6	Date: 10/12/06	Date:

inspector to Rev C Dn

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



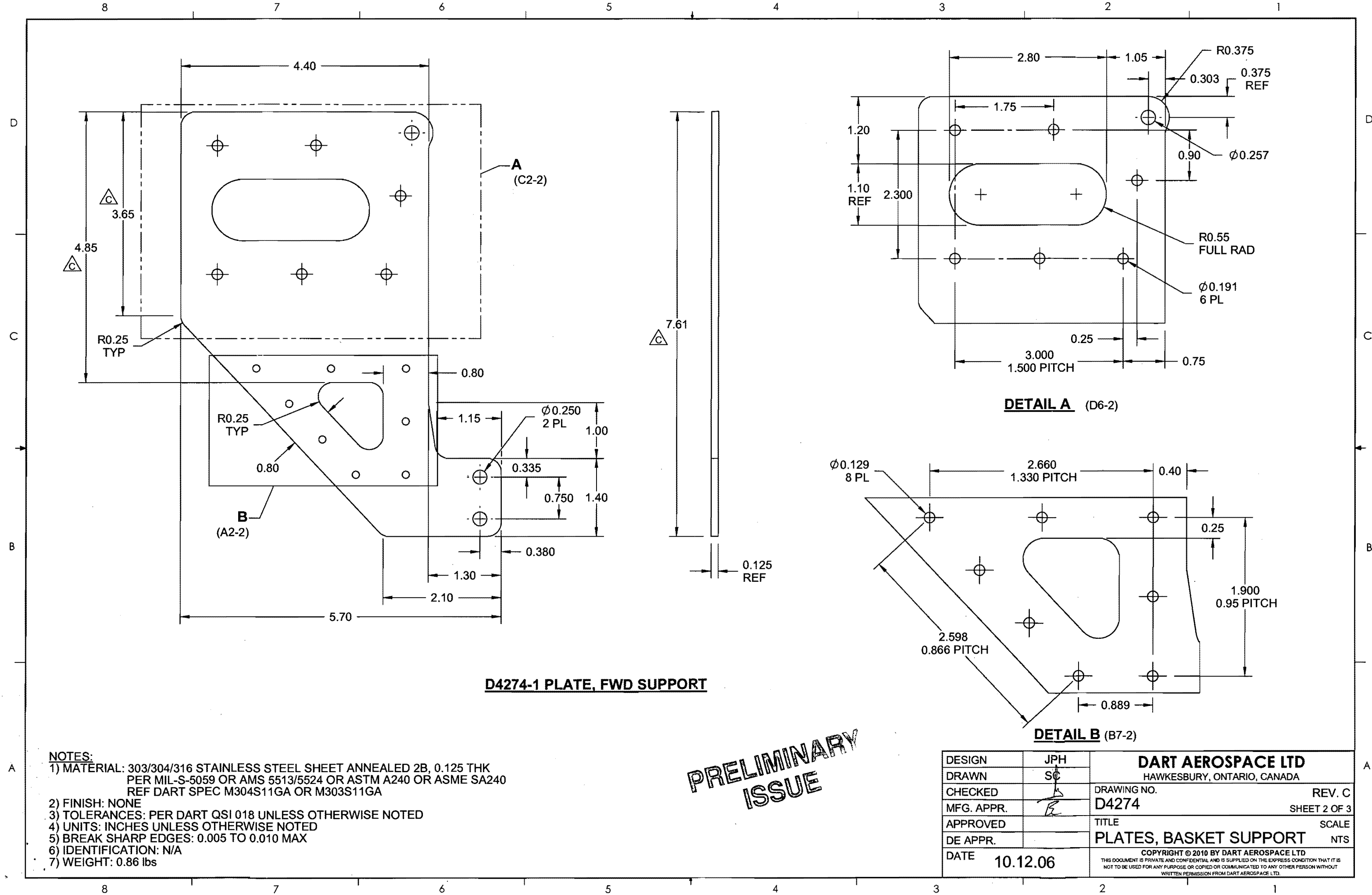
D4274-1 PLATE, FWD SUPPORT

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.78 lbs

1064480

**PRELIMINARY
ISSUE**

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4274	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		PLATES, BASKET SUPPORT	NTS
DATE	10.12.02	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.86 lbs

PRELIMINARY
ISSUE

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4274	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PLATES, BASKET SUPPORT	NTS
DATE	10.12.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

L Lacelle

From: Mike Petsche [mpetsche@dartaero.com]
Sent: December 6, 2010 1:56 PM
To: Sridhar Chintapalli; 'Chris Provencal'; 'L Lacelle'; 'Eric Charbonneau'; 'David Duval'
Cc: 'David Shepherd'
Subject: RE: NEW PARTS PLEASE!!!!
Oh.....and they need t be fedex'ed to us today!

Thanks

XOXOXOXOX

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: December 6, 2010 1:55 PM
To: Sridhar Chintapalli; 'Chris Provencal'; 'L Lacelle'; 'Eric Charbonneau'; 'David Duval'
Cc: 'David Shepherd'
Subject: NEW PARTS PLEASE!!!!
Importance: High

D4274-1 and D4274-3 *42*

I know it's a little late in the game.... But Sri, as I mentioned in my email this weekend, The basket is still a little too high for the 407

Could you drop everything right away and modify the D4274-1 and D4274-3 plates to make them an additional ½" taller than they are. Basically do exactly what you did before. But we need an additional ½"

Mike Petsche
DART Aerospace
Design Manager

613-632-5200
514-833-1657

12/06/10